



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBT18560-3
Job Sheet 170256



Part No: RBT18560-3

Job Qty: 6 ea

Part Name: Ring



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/12/18

Job Tracking No:

Due Date: 1/31/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBT18560 Rev 4 IPP Rev A 17.11.13 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		1/30/18	0.00	0.00	Start Up Machining-4		
100	Bandsaw	6 pcs		1/30/18	0.00	0.60	Bandsaw1		
120	Mori Seiki	6 pcs		1/31/18	0.00	3.00	MORI SL2500Y		
130	QC	6 pcs		1/31/18	0.00	0.00			
140	Lathe Conv	6 pcs		1/31/18	0.00	0.00			
150	QC	6 pcs		1/31/18	0.00	0.00	QC2 Machining-4		
151	QC	6 pcs		1/31/18	0.00	0.00	QC8 Machining-4		
160	QC	6 pcs		1/31/18	0.00	0.00	QC5		
170	Outsource	6 pcs		1/31/18	0.00	0.00	Outsource12		
180	Packaging	6 pcs		1/31/18	0.00	0.00	Packaging2		
190	QC	6 pcs		1/31/18	0.00	0.00	QC6		
200	Packaging	6 pcs		1/31/18	0.00	0.00	Packaging3-2		
230	QC21-SA	6 Ea		1/31/18	0.00	0.00			

Part Op 90 - -35.25" makes 26 parts as per Eugene routing.

Descriptions: 100 - Cut blanks to 1.25"

120 - 1-Machine as per folio FB 730 FOLIO REV: _____ DWG REV: _____ 2-Deburr
170 - -Issue P/O to Groupe Altech; PO 038997 -Black oxide finish, MIL-C-13924C Class 1 -Certificate of
Conformity is required

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	MT-A513-T-2.625W0.250	1	12	0	0

Part Specifications

Specifications could not be found.

Plex 1/12/18 10:50 AM Dart.lajeunesse.marie

DART
AEROSPACE
S037206



Ring

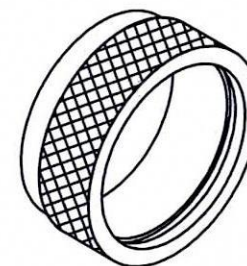
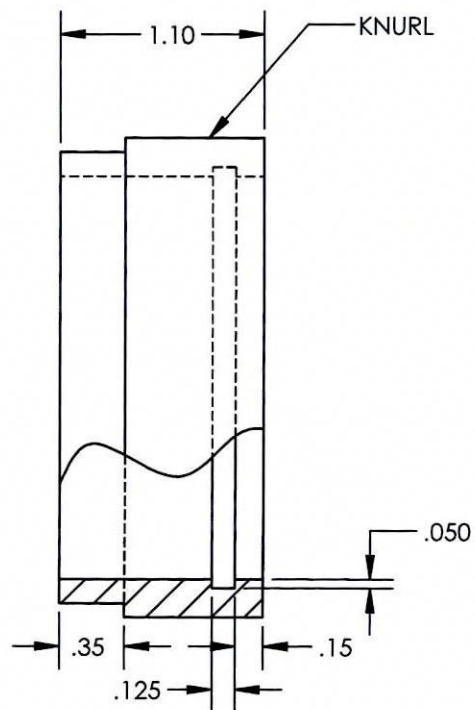
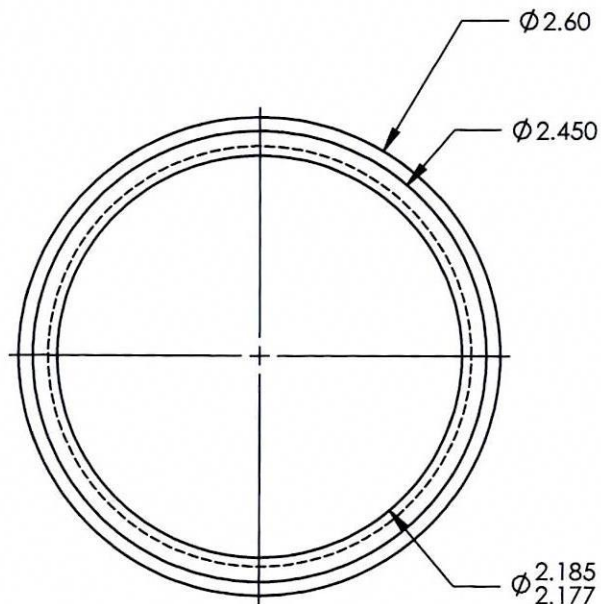
PART NO: RBT18560-3
Original Serial #: S037206
Revision:
Operation: Start up Operation
Change No:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

01/31/18
Job No: 170256

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REVISIONS			
REV	ECR	DESCRIPTION	DATE
			INITIAL
			APPROVED



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 18560

170256 MLS
1801-12

(-3)
RING

DART AEROSPACE	
TITLE ENGINE/GEARBOX SEAL PULLER	
DWG NO. RBT18560-3	REV 4
MAT'L DOM HEAT TREAT	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
FINISH BLACK OXIDE	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± 5°
DRAWN BY: COLE	.X ± .1 SURFACES = 125/
CHECKED:	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
OPPS APPR:	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
QA APPR:	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
APPROVED: WEIL	USED ON MODEL SEE SHT 1
SCALE 1:1	DATE 5/2/2002
SHEET 3 OF 6	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By																																																									
								Lead hand / Supervisor Approval Verification																																																									
								QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

**ENGINEERING ORDER #** TEO17-643

SCALE: NTS

SHEET 1 OF 1

DRAWING NO. RBT18560

REV: 4

EFF.: NEXT ORDER

CHANGE CATEGORY

☐ MAJOR ☒ MINOR

DATE 17.09.07

TITLE: ENGINE/GEARBOX SEAL PULLER

APPROVED:

MFG. APPR.:

CHECKED:

DRAWN: VM 09/25/2017

TRANSACTION CODE (TC):
A-ADD C-CREATE
R-REVISE D-DELETE

REASON: MATERIAL NEED UPDATED

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USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION
FROM DART AEROSPACE LTD.

WAS : PART# RBT18560-3 Rev 4 MATERIAL : DOM
IS : PART# RBT18560-3 Rev 4 MATERIAL : A513 TUBING AS PER MT-A513-T

DOCUMENTS EFFECTED: ☐ PATTERN ☐ INSTALL INSTRUCTIONS ☒ BOM



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO038997

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO038997
PO Date: 2/8/18
Due Date: 2/15/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Baker, Diane
Phone: dbaker@dartaero.com

E-MAILED
FEB 12 2018

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pynt Terms: Net 30
Freight Terms:
Special Comments:

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	169930	RBW6405G02131-3G-5	Quarter Bell -Issue P/O to Groupe Altech: P/O _____ -Zinc plate, ASTM B633 TYPE 1 SC2 - Certificate of Conformity is required	Firmed	2/15/18	4 pcs	0 pcs	4 pcs	\$11.25/pcs	\$45.00
						✓ 4x			At 18/02/15	
2	170256	RBT18560-3	Ring -Issue P/O to Groupe Altech: PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	2/15/18	7 pcs	0 pcs	7 pcs	\$6.3158/pcs	\$44.21
						✓ 7x			At 18/03/05	
3	170479	646.3910	Shim Issue P/O: _____ Cad Plating, CAD PLATE PER QQ-P-416, TYPE II, CLASS 2, CL2	Firmed	2/15/18	33 pcs	0 pcs	33 pcs	\$4.16/pcs	\$137.28
						✓ 33x			At 18/02/15	
4	170481	646.3912	Shim Issue P/O: _____ Cat Plating, CAD PLATE PER QQ-P-416, TYPE II, CLASS 2, CL2	Firmed	2/15/18	22 pcs	0 pcs	22 pcs	\$4.16/pcs	\$91.52
						✓ 22x			At 18/03/05	
5	170703	RBT18560-9	Cross Bar -Issue P/O to Groupe Altech: PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	2/15/18	6 pcs	0 pcs	6 pcs	\$6.3158/pcs	\$37.89
						✓ 6x			At 18/03/05	
6	171015	RBW6405G02131-3G-5	Quarter Bell -Issue P/O to Groupe Altech:	Firmed	2/15/18	4 pcs	0 pcs	4 pcs	\$11.25/pcs	\$45.00
						✓ 4x			At 18/02/15	



Certificat de Conformité / Certificate of Compliance

(006598-2)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

006598 - 2

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.		Bon de commande Client Customer Purchase Order No.				
19-Feb-2018		Curtis Anderson			038997				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Quantités / Quantities Qté NC/ NC Qty		Qté Scrap/	À venir/ Back Order
2	RBT18560-3 Rev.	RBT18560-11 BLACK OXIDE FINISH MIL-C-13924C CLASS 1	OXIDE-BLACK CH	7	7	0	0	0	0
4	646.3912 Rev.	646.3912 CAD PLATE PER QQ-P-416 TYPE 2 CLASS 2 ,CL2	CADMIUM CH	22	22	0	0	0	0
5	RBT18560-9 Rev.	RBT18560-9 BLACK OXIDE FINISH MIL-C-13924C CLASS 1	OXIDE-BLACK CH	6	6	0	0	0	0
7	RB6796941-201-4 Rev.	PLUG BLACK OXIDE MIL-C-13924C CLASS 1	BLACK-OXIDE CH	6	6	0	0	0	0

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.